

28X51

# Work Order ID 62360



Tuesday, September 28, 2010 11:20:35 AM

Item ID:	D3875-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Floor Protector					
Start Date:	9/28/2010	Start Qty:	3.00			
Required Date:	10/5/2010	Req'd Qty:	3.00			
Reference:						

Approvals:	Process Plan:		Date:	10/9/05	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>		<b>Revision Nbr</b>							
D3875		Rev A							
100		0.00							
	HandThermo								
	Hand Finishing Thermoforming								
	Memo	0.00							
	1-Cut Sheet to required Blank size								
105		0.00							
	Dry Material								
	HandThermo								
	Hand Finishing Thermoforming								
	Memo	0.00							
	Dry Sheet as per 484022 POLYCARBONATE								
	Temp: 240F								
	Time IN: 7:30 10/10/05								
	Time OUT: 7:00 10/10/06								

X3

BB  
10/10/06

BB  
10/10/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 62360**

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Page 2

Item ID: D3875-1

Accept

Revision ID:

Item Name: Floor Protector

Start Date: 9/28/2010 Start Qty: 3.00

Required Date: 10/5/2010 Req'd Qty: 3.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110



Thermoform

Thermoforming Machine

Memo

1-Machine Set-Up  
2-Pre-heat Tool to required temp.  
3-Thermoform as per Dwg and Folio #FTA0xxusing tool DT9435  
Dwg Rev: A  
Folio Rev: B

0.00

0.00

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

Visuallly inspect part for proper formation and texture

0.00

0.00

130



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

BB 10/10/06.

(X3) BB 10/10/06.

(X3) BB 10/10/06.

(X3) BB 10/10/06.

W/O:		WORK ORDER CHANGES					
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**Work Order ID 62360**

Tuesday, September 28, 2010 11:20:35 AM



Page 3

Item ID: D3875-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector

Start Date: 9/28/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 10/5/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

(x3) 6h 10/10/07

150

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

Complete FAI document

(x3) 6h 10/10/07

160

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

8 10/10/12

(x3)

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 62360**

Tuesday, September 28, 2010 11:20:35 AM

Page 4

Item ID: D3875-1

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Setup Start

Revision ID:

Stop

Item Name: Floor Protector

Start Date: 9/28/2010 Start Qty: 3.00

Required Date: 10/5/2010 Req'd Qty: 3.00

Cust Item ID:

Customer:



Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo <i>PPP</i> <i>62359</i>	0.00  0.00							<i>CE 10/10/13 (3)</i>
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							<i>10/10/13</i> <i>ME</i> <i>10-10-13</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, September 28, 2010 11:20:39 AM

Page 1

Work Order ID: 62360



Parent Item: D3875-1



Parent Item Name: Floor Protector

Start Date: 9/28/2010

Required Date: 10/5/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev. A 09.02.06 New Issue DL  
Add Step 105 Dry Material 10/04/21 DL

IPP Rev.B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	2,497.890	9.84	29.52			

Lexan Sheet

Location

therm

113127

Loc Qty

2497.89

2497.89

Loc Code

3

B  
10/10/06.

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	62360
<b>Description:</b> Floor Protector		<b>Part Number:</b>	D3875-1
<b>Inspection Dwg:</b> D3875	<b>Rev:</b> A	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

<b>Measured by:</b>	Wk	<b>Date:</b>	10/10/07
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#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.042	✓			
0.080	Min	0.083	✓			
45.2	+/-0.100	45.25	✓			
21.8	+/-0.100	21.8	✓			
1.4	+/-0.100	1.44	✓			

<b>Measured by:</b>	Wk	<b>Date:</b>	10/10/07
<b>Audited by:</b>	JP	<b>Date:</b>	10/10/07
<b>Prototype Approval:</b>	N/A	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	JA

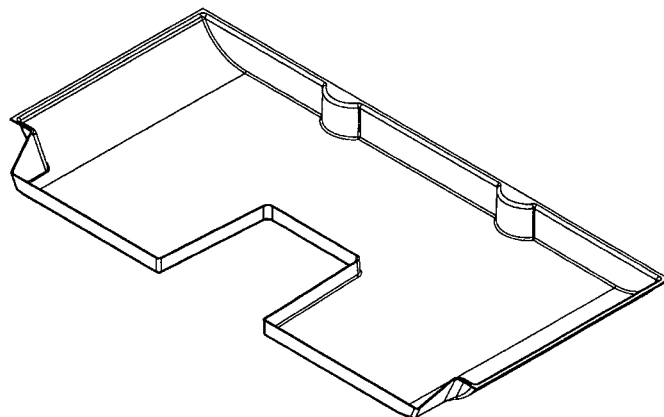
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**NOTE:** Date & initial all entries



**D3875-1 FLOOR PROTECTOR (206B)**

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 62360  
BS10925

**RELEASED**  
29/05/05 NPB

**NOTES:**

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3875-1" USING VIBRATING STYLUS
- 7) WEIGHT: 4.0 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9475 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

A NEW ISSUE		PH	09.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>AK</u>		
DRAWN	<u>AK</u>		
CHECKED	<u>AK</u>		
MFG. APPR.	<u>AK</u>		
APPROVED	<u>AK</u>		
DE APPR.	<u>AK</u>		
DATE	09.01.29		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3875</b>	REV. A
TITLE <b>FLOOR PROTECTOR (206B)</b>	SHEET 1 OF 2
SCALE NTS	

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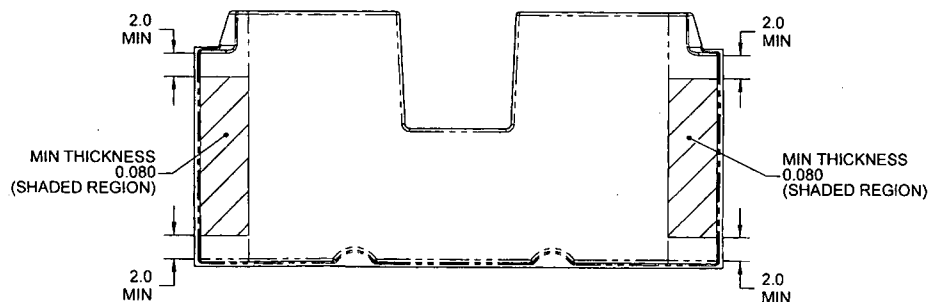
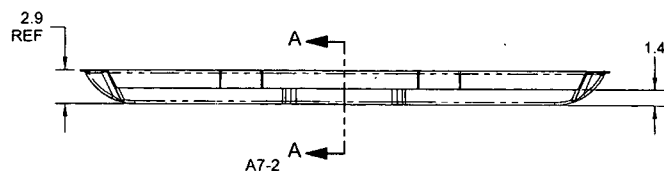
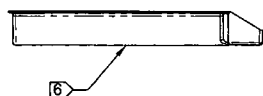
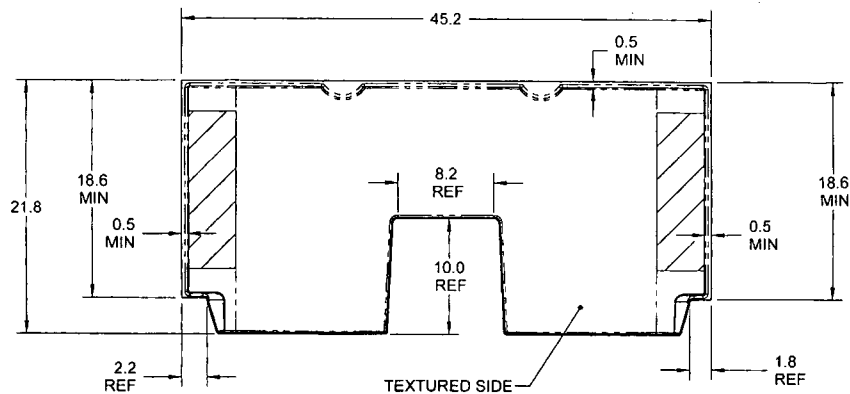
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



**SECTION A-A** B4-2

**D3875-1 FLOOR PROTECTOR (206B)**

**RELEASED**  
08/05/05

DESIGN	PA	<b>DART AEROSPACE LTD</b>	
DRAWN	PA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PA	DRAWING NO.	REV. A
MFG. APPR.	PA	D3875	SHEET 2 OF 2
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	FLOOR PROTECTOR (206B)	NTS
DATE	09.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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